

Work Order ID 111062

111062

Page 1

February-13-14 1:16:11 PM

Item ID: D4150-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Plate

Start Date: 08/01/2014 Start Qty: 40.00

40

Cust Item ID:

Required Date: 08/01/2014 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:



Date: 14-02-13 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4150

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

Cut as per dwg D4150

Prog Rev: _____

Dwg Rev: _____

ISSUE PO P023011

POSSIBLE SUPPLIER: LOEBSACK WATERJET

Deburr as required

105

Receive & Inspect for Damage & Mat'l Certs

0.00

105

Packaging

Packaging

Memo

0.00

umg 2/18/14

P440/9 (40)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Work Order ID 111062

February-13-14 1:16:12 PM

111062

Page 2

Item ID: D4150-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Arm Plate
Start Date: 08/01/2014 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 08/01/2014 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 *115* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				40			
125 *125* Small Fab Small Fab	Memo DEBURR A/R	0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00				40X			

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Work Order ID 111062

February-13-14 1:16:12 PM

111062

Page 3

Item ID: D4150-3 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Arm Plate
Start Date: 08/01/2014 Start Qty: 40.00 *40* Cust Item ID:
Required Date: 08/01/2014 Req'd Qty: 40.00 *40* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MCJ 1405-13

14-5-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

February-13-14 1:16:17 PM

Page 1

Work Order ID: 111062

111062

Parent Item: D4150-3

D4150-3

Parent Item Name: Arm Plate

Start Date: 08/01/2014

Required Date: 08/01/2014

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4150-3P		Purchased		No			Each	0.0000		40			
D4150-3P									**				
Arm Plate													

[Handwritten signature]
[Handwritten signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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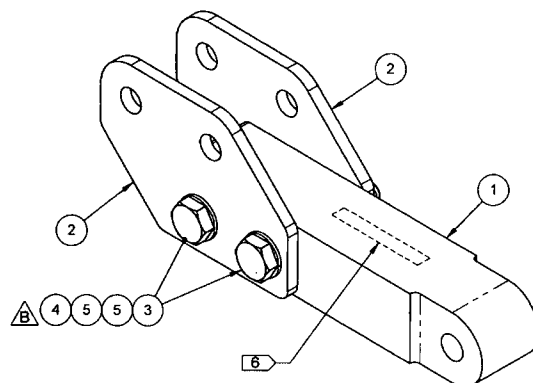
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge </div> <div> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other </div> </div>		

111062
MLJ 14-01-10

ITEM	QTY	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-11	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER



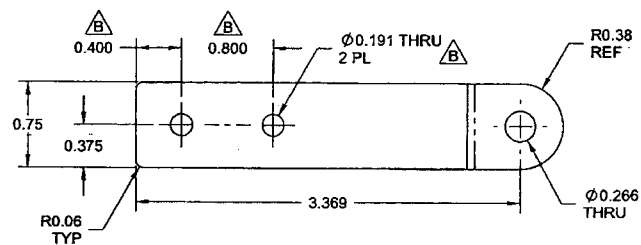
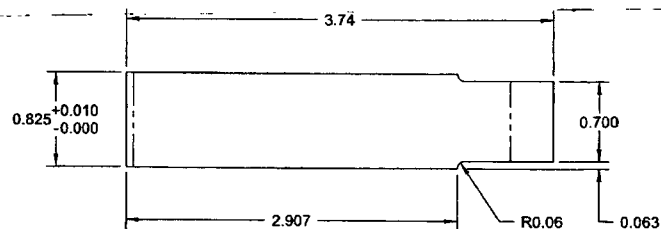
D4150-041 ATTACHMENT ARM ASSY

RELEASED
2010-07-16

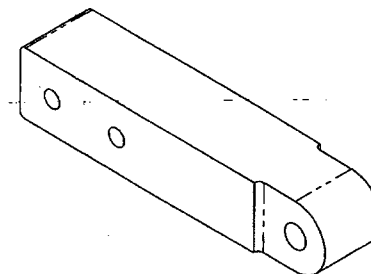
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs

B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø.191 2 PL REPLACES Ø.129 3 PL (ZN C6-2, C7-2, B4-3 & B5-3). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.08
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DRAWING NO. D4150		
CHECKED	REV. B		
MFG. APPR.	SHEET 1 OF 3		
APPROVED	TITLE ATTACHMENT ARM ASSY		
DE APPR.	SCALE NTS		
DATE	10.07.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4150-1 ARM

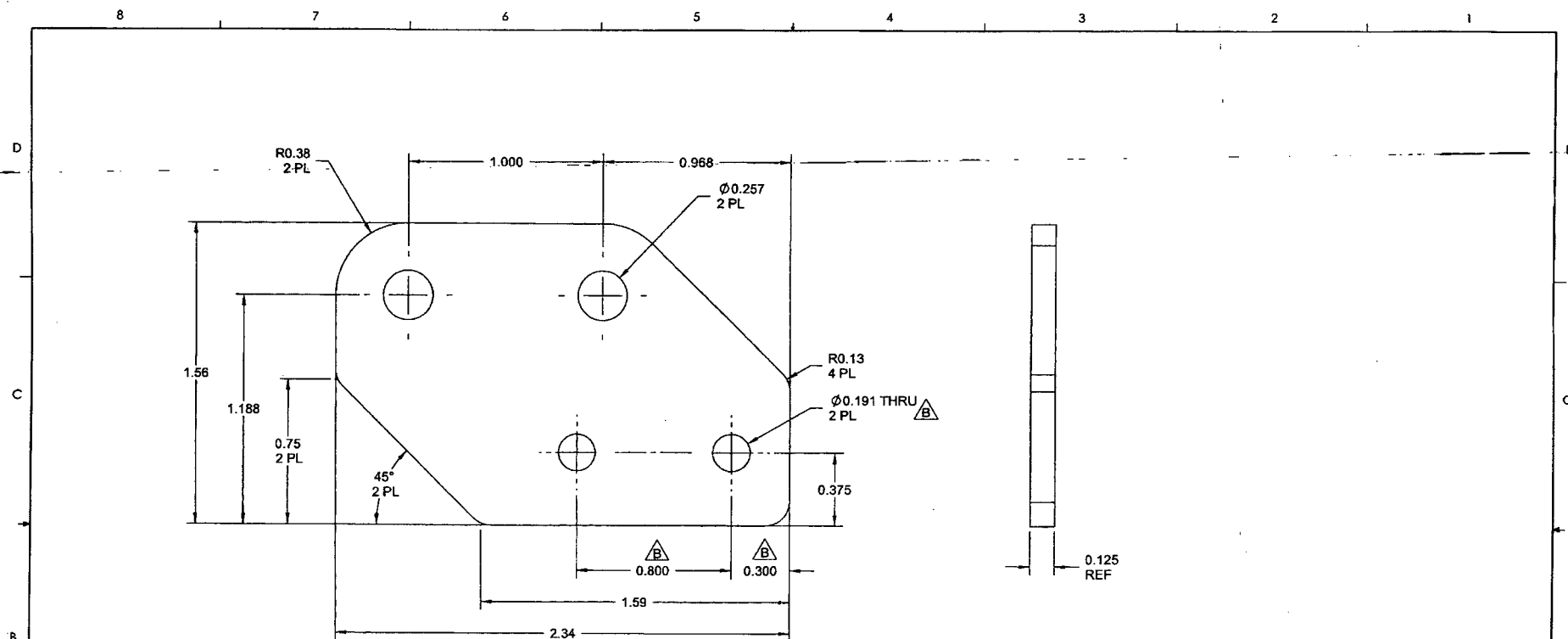


RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
DATE	10.07.08	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4150-3 ARM PLATE

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4150	REV. B
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		ATTACHMENT ARM ASSY	SCALE
DE APPR.			NTS
DATE	10.07.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23011

Purchase Order Date 2/14/2014

PO Print Date 2/14/2014

Page Number 4 of 9

Order From :

VC-LWC001

Ship To : DART AEROSPACE LTD

LOEBSACK WATERJET CANADA LTD.
55 NORTHFIELD DR. E.
P.O.BOX 339

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

WATERLOO, ONTARIO N2K 3T6

Contact Name

Vendor Phone

Buyer

Michael Gregoire

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Line Total: \$479.00

11 D3405-1F

GHW/ Bracket

3/28/2014

40.00

\$10.40

\$416.00

Yes

3/28/2014

Each

Manufacture as per drawing D3405 rev.b
B110741

Line Total: \$416.00

12 D4150-3P

Arm Plate

3/28/2014

40.00

\$4.80

\$192.00

Yes

3/28/2014

Each

Manufacture as per drawing D4150 rev.b
B111062

Line Total: \$192.00

13 D4151-1P

Lower Hardpoint Plate

3/28/2014

40.00

\$5.45

\$216.00

Yes

3/28/2014

Each

Manufacture as per drawing D4151 rev.c
B112572

PO Instructions: PROCUREMENT QUALITY CLAUSES

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A042 DART NOTIFICATION BY SUPPLIER

Note:



55 Northfield Dr., E., Box 339
Waterloo, On. N2K 3T6
(519)570-6590
F. (519)893-4252

Certificate of Compliance

Sold To: DART Aerospace

Purchase Order Nu ID PO23011

Item	Quantity	Part Number	Revision	Description	Mtl. / Thk.	HT Number
6(19)	12	D2803-1	b	BRACKET	6061-T6 / 0.50"	11/12/168D0
23(20)	12	D2803-2	b	BRACKET	6061-T6 / 0.50"	11/12/168D0
5(18)	12	D2804-1	c	BRACKET	6061-T6 / 0.50"	11/12/168D0
4(17)	12	D2804-2	c	BRACKET	6061-T6 / 0.50"	11/12/168D0
10(9)	10	D4093-3	d	BRACKET	6061-T6 / 0.750"	22/11/036D6
20(6)	30	D3065-5	b	STEP LEG	5052-H32 / 0.080"	3C529#2
24(24)	24	D2561P	b	LUG	6061T6 / 0.25"	08/11/010D6
3(18)	150	D2838	c	CLAMP	304 SS / 0.063"	A1303988
17(16)	60	D2519	d	CLAMP	304 SS / 0.063"	A1303988
2(17)	40	D3414-1F	c	CLAMP	304 SS / 0.100"	500400
15(14)	60	D4149-1	c	CROSSTUBE LUG	304 SS / 0.120"	350420
12(11)	40	D4150-3	b	ARM PLATE	304 SS / 0.120"	350420
13(12)	40	D4151-1	c	L HARDPOINT PL	304 SS / 0.120"	350420
14(13)	40	D4515-3	c	U HARDPOINT PL	304 SS / 0.120"	350420
16(15)	40	D4148-1	c	CROSSTUBE LUG	304 SS / 0.120"	350420

This is to certify that the whole of the supplies detailed hereon has been inspected, tested, packed, and unless otherwise stated, conform in all respects with the requirements of the contract or order.

Name: Derek Loebsack

Title: President

Sign:

Dated:

05-01-14

THYSSENKRUPP MATERIALS NA

Certificate of Mill Test Results

BL PEC-000000-000

Pg 1/1

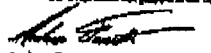
PO/Rel

We certify that this is a true copy of the report furnished by the producer of the metal, or data resulting from tests made in approved labs.

Signed by:

Attn: RICK

PART NO.

<p>ThyssenKrupp</p> <p>ThyssenKrupp Stainless USA</p>	<p>INSPECTION CERTIFICATE</p> <p>CERTIFICADO DE INSPECCION</p> <p>ABNÄHMEPROTOKOLLENS</p> <p>according to / de acuerdo con / nach EN 10204-3.1</p>	<p>Document number / Nº de certificado / Dokumentationsnummer 0000032224 /</p> <p>Page / Página / Seite 1 / 1</p>				
<p>1 ThyssenKrupp Drive, P.O. Box 13000; Calvert, AL 36613-1300</p> <p>CLIENT METALS SALES LIMITED</p> <p>988 DERRY ROAD EAST SUITE 305</p> <p>MIRISSIGALBA ON L6T 2J8</p> <p>CANADA</p>	<p>Customer's name / Client / Kundenname CLIENT METALS SALES LIMITED, MISSISSAUGA</p> <p>Customer's order / number / Nº de Pedido Client / Auftragsnummer TO-1846</p> <p>Manufacturer's registration no. / Nº de Pedido KKS customer / Lieferantnummer 901147759 / 001</p> <p>Delivery term no. / Nº de entrega / Lieferungs-Nr. 85228223 / 010</p> <p>Product / Fabrica / Design SHEET/PLATE/BLANK</p> <p>Steel grade and quality / Acero Fabricante und Designación TYPE 304 L/304</p>					
<p>Form of delivery / Conditional description / Lieferbedingung ASTM A340/A340M, ASME SA-340 Se/J Part A Ed.2010 ASTM A480/A480M, ASME SA-480 Se/J Part A Ed.2010</p>						
<p>Customer's material no. / Nº Material del Cliente / Materialnummer des K.</p>	<p>Product description (Dimensions / width / length / Dimensions / Gewicht / Breite / Länge / Produktbeschreibung (Stärke / Breite / Länge)</p>	<p>Heat treatment / Proceso de tratamiento / Wärmebehandlung</p>	<p>Final customer acceptance</p>			
	<p>3.06 mth x 1,219.28 mm x 2,438.40 mm 0.180 inch x 48.000 inch x 96.000 inch</p>	<p>ADD</p>	<p>OK / 38</p>			
<p>Serials / Serials / Nº de Control Número</p>	<p>Heat treated Temple Temple</p>	<p>Actual weight Peso real / Gewicht</p>	<p>Old No. / Antig. No. / Eig. Nr.</p>	<p>New No. / Nuevo No. / Eig. Nr.</p>	<p>Serials / Serials / Nº de Control Número</p>	<p>Serials / Serials / Nº de Control Número</p>
<p>0053016 0061012</p>	<p>32 32</p>	<p>4,890 lb / 2,218 kg 4,895 lb / 2,218 kg</p>	<p>713000 718000</p>	<p>594420 560420</p>	<p>1000088330 1000088330</p>	<p>1000088332 1000088332</p>
<p>Heat / Temperatura / Temperatur</p>	<p>Chemical composition / Composición Química / Chemische Zusammensetzung</p>					
<p>350420 350420</p>	<p>350420 350420</p>	<p>350420 350420</p>	<p>350420 350420</p>	<p>350420 350420</p>	<p>350420 350420</p>	<p>350420 350420</p>
<p>Product Fabrica / Produkt</p>	<p>TRANSVERSE</p>					
<p>Inspection lot / Lote de Inspección / Lot</p>	<p>Y80.2% PSI / MPa</p>	<p>T8 PSI / MPa</p>	<p>E8. A3* %</p>	<p>H88</p>		
<p>1000088330 1000088332</p>	<p>43,400 / 302 43,945 / 305</p>	<p>83,111 / 642 85,111 / 642</p>	<p>95.9 98.1</p>	<p>42 32</p>		
<p>Dimensional analysis / Dimensionen / Größe / Maße / Dimensionen Test of identity (dimensions analysis) / Control of identified (analysis) / Identifizierung (Analyse) / Identifizierung (Analyse)</p>						
<p>OK OK</p>						
<p>No weld repairs</p> <p>No intentional additions of Mercury compounds were made or used</p> <p>Form of packaging / Form of packaging / Form of packaging</p> <p>EU RoHS Directive 2002/95/EC Compliant</p> <p>Country of Heat as per ISO 3165-1</p>						
<p>Originator of the document / Originator del documento / Hersteller der Zeichnung ThyssenKrupp Stainless USA, LLC An ISO 9001:2008 certified company</p>						
<p>The information provided is a true copy of data on the file / La información proporcionada es una copia verdadera de los datos del expediente / Die bereitgestellten Informationen sind eine Kopie der Daten</p> <p style="text-align: center;"></p> <p style="text-align: center;">Andrew Pollock Phonax: +1 361 620 3482</p> <p style="text-align: center;">Director of sales / Director de ventas / Verkaufsdirektor</p>						
<p>Date of delivery and delivery / Fecha de entrega y entrega / Datum der Lieferung / Lieferung 12/12/2012</p>						